

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000924**Date Inspected:** 27-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	77, 89 & 114 Meter Mock-Up & OBG	

Summary of Items Observed:

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Ken Jobes, Scott Croff, and Roscoe Dixon performing fabrication inspection out on the shop floor today. Mr. Croff observed heat straightening activities per HSR-13 and welding on 114 Meter MUSC-MA107 Face A skin plate. In addition to the above Mr. Croff wrote a non-conformance for heat straightening activities from the previous evening per the instructions of the Task Leader Mr. Robert Cuellar. Mr. Jobes observed the drilling of bolt holes in rib stiffeners and the welding of the root pass for an OBG exterior plate. Mr. Jobes also observed the tack welding of stiffeners to OBG side plates and for the 89 Meter Mock-Up MUSB-MA38 skin plate E he observed some of the evenings welding. Mr. Dixon observed welding of the longitudinal stiffeners on the 89 Meter Mock-up, MUSB-MA38 A/B skin plate E and witnessed the taking of sample plates for batch 4 due to yield strength problems from a previous test.

All observations/verifications by Quality Assurance staff appeared to be in compliance with the project specifications with exception of that noted above.

This Quality Assurance Inspector performed magnetic particle and ultrasonic testing on MUSB MA112 upper skin plate E plate to plate welds and longitudinal stiffeners to skin plate welds. For details of non-destructive testing carried out see magnetic particle report TL-6028 and ultrasonic report TL-6027 dated November 27, 2007.

Summary of Conversations:

No conversations held today.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
